

Date: Friday, 9/21/2007 1:01:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG			
Job Number	: 34790						
Estimate Number	: 10178						
P.O. Number	: N/A		Part Number	: D25941			
This Issue	: 9/21/2007	S.O. No.	: N/A		Drawing Number	: D2594 REV C	
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: N/A		Drawing Revision	: C			
Previous Run	: 33450		Material	: N/A			
Written By			Due Date	: 10/10/2007			
Checked & Approved By			Qty:	500	Um:	Each	
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
		Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	104598-2-61 103 06 1-9.75 +4 ¹ 19.51 Batch 103 156-3.22 24 07/10/16
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.	07/10/16
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	07/10/16 363
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 07/10/16 363
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1	07-10-17 363

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/16/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:01:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 34790

Part Number: D25941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M105068



363X

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

ML 07/0/17

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-18

X363

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1-P-8

MSL 07-10-18

363

9.0 QC21

FINAL INSPECTION/W/O RELEASE



363

Comment: FINAL INSPECTION/W/O RELEASE

MSL 07/0/18

Job Completion



U 07/0/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34790
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>RJ</i>	Audited by:	<i>J.F.</i>	Prototype Approval:	N/A
Date:	<i>07/10/16</i>	Date:	<i>07/10/16</i>	Date:	

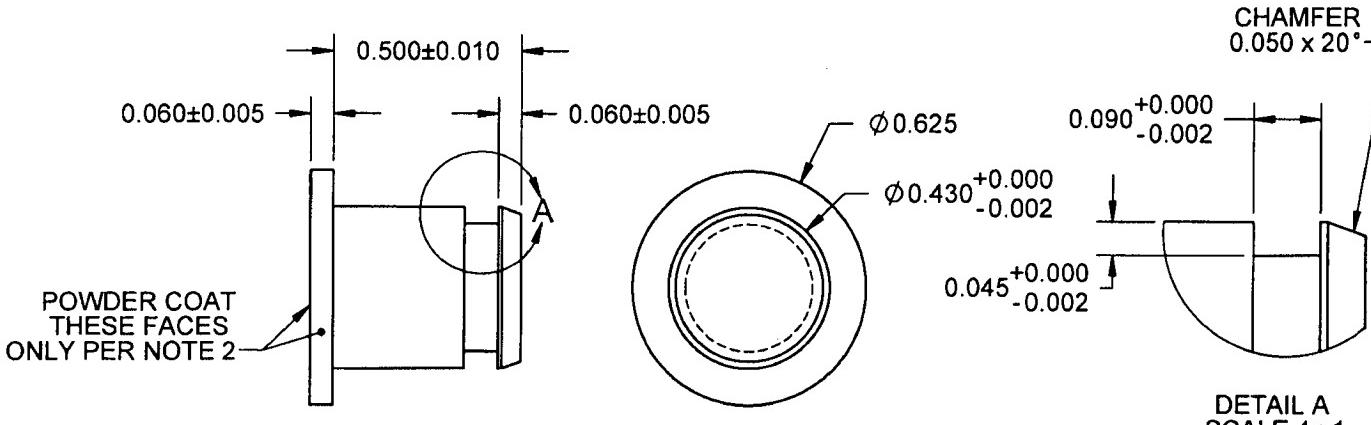
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	JL

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1

REVISIONS SEE
06.11.28 - CH

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



D2594-1 PLUG

D2594-1 PLUG NOTES:

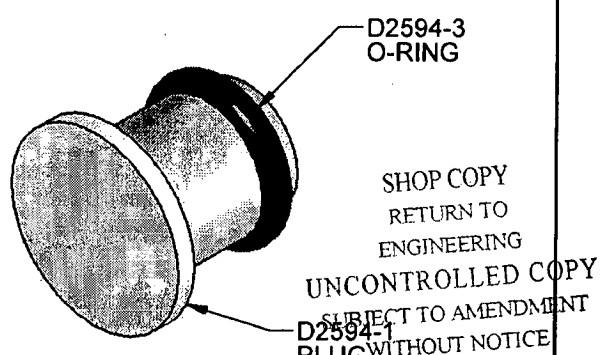
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

COPYRIGHT © 1996 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.